

Work Order ID 116400

Monday, April 14, 2014 11:00:40 AM

116400

Page 1

Item ID: D3552-19

Revision ID:

Item Name: Door Prop

Start Date: 4/14/2014 Start Qty: 1.00 *1*

Required Date: 4/17/2014 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: CZ Date: 14/04/14

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3552

K

100

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 23791
Purchase Part Number: B8-154-387-060NX
Supplier: LS Technologies
Certificate of conformity is required

0.00

0.00

CZ 14/04/14 (1)

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure certificate of conformity is attached

0.00

0.00

P 14/4/14 (1)

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

Test for correct pressure

0.00

0.00

DAS
21
4/14/171

Work Order ID 116400

Monday, April 14, 2014 11:00:40 AM

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Start Date: 4/14/2014 Start Qty: 1.00 *1*

Required Date: 4/17/2014 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ST261

0.00

130

Packaging

Memo

0.00

Packaging

11 14-4-17DAS
26
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14-4-17AA 14-04-17Change to RD5460
P2015842

Picklist Print

Monday, April 14, 2014 11:00:40 AM

Page 1

Work Order ID: 116400

116400

Parent Item: D3552-19

D3552-19

Parent Item Name: Door Prop

Start Date: 4/14/2014

Required Date: 4/17/2014

Start Qty: 1.00

Required Qty: 1.00

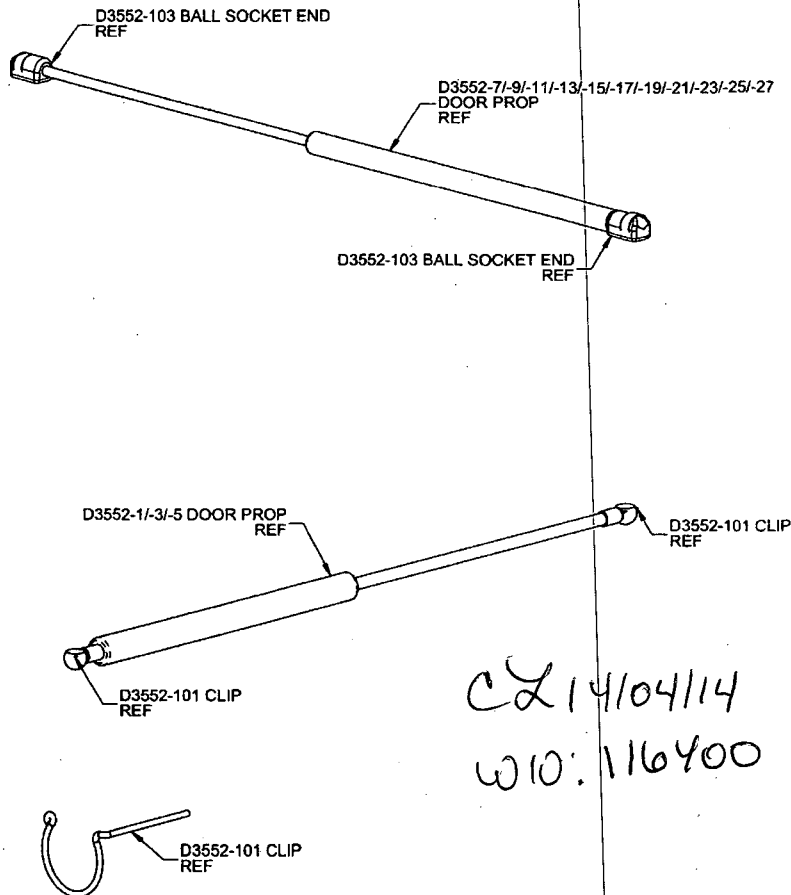
Comments: IPP Rev:A 10.09.24 new issue DD Verf:EC
10.12.03 as per dwg rev.G DD verf:EC
PER ECN12-624 DD verf:EC

IPP Rev:D
IPP Rev:E 12.07.30 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B8-154-387-060NX		Purchased		No		110	Each	0.0000	1	1			
B8-154-387-060NX										**			
Gas Spring													

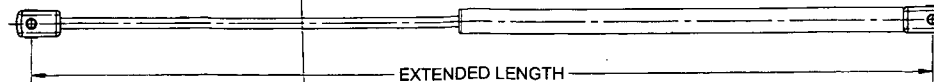
P4/14/16 (1)

SPECIFICATION CONTROL DRAWING



RELEASED
2012-07-24

K	ADD "X" TO LS TECHNOLOGIES P/Ns TO DESIGNATE "EXTRA DAMPING" FOR D3552-15/-17/-19/-25/-27. REASON: PAR12-209.	MB	12.07.16
J	ADD P/N D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -19. STROKE FOR -15, -17 AND -19 WAS 139/8.06 NOW 154/8.06. EXTENDED LENGTH FOR -15, -17 AND -19 WAS 386/15.2 NOW 387/15.2.	AP	11.12.07
I	ADD P/N D3552-23	RF	11.10.11
H	ADD P/N D3552-21	DC	11.03.10
G	FOR -15, FORCE: 300/87.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 386/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.08.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DE		
DRAWN	DE		
CHECKED	MD		
MFG. APPR.	DE		
APPROVED	MD		
DE APPR.	DE		
DATE	12.07.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3552 REV. K SHEET 1 OF 2 TITLE DOOR PROP SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-220-530-140N
D3552-15	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300NX
D3552-17	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156NX
D3552-19	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060NX
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-167-410-070N
D3552-23	DOOR PROP	190/7.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-070N
D3552-25	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-300NX
D3552-27	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-156NX
2 D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9
3 D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10

D3552-X DOOR PROP

RELEASED
2012-07-24

NOTES:

- 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-11-31-5 DOOR PROPS
- 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-71-91-111-131-151-171-191-211-231-251-27 DOOR PROPS

DESIGN	4E	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. K
MFG. APPR.		D3552	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOOR PROP	NTS
DATE	12.07.16	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23791

Purchase Order Date 4/14/2014

PO Print Date 4/14/2014

Page Number 2 of 2

Order From :

VC-LST0001

Ship To : DART AEROSPACE LTD

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 306 683 5000

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

3	B8-154-387-060NX	Gas Spring	4/17/2014	1.00	\$26.50	\$26.50
			Yes	Each		
			4/17/2014			

AS PER DWG D3552-19 REV. K
B116400
CHARGE TO RD5460/P2015842

Line Total: \$26.50

4	71401-45	PROCUREMENT QUALITY CLAUSES	4/17/2014	1.00	\$0.00	\$0.00
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Procurement Quality Clauses
A004 faa-pma/tso
A005 right of entry
A016 personnel qualification
A025 certification of conformance
A040 notification of quality escape
A043 retention of quality documents

No
4/17/2014

Line Total: \$0.00

PO Total: \$1,353.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 2

Change Date: 4/14/2014

Saskatoon, SK S7N 1Y6
314 Jessop Ave
Saskatoon, SK S7N 1Y6
Ph # (306) 683-5000

P.O. No.	Date	Invoice #
23791	4/15/2014	11063

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
4/15/2014		

Qty	Description
20	D3969-3 B115924 Stainless Gas Spring
1	D3552-17 B16399 Gas Spring
1	D3552-19 B116400 Gas Spring
Shipping Via FED EX Tracking # 798554572428	



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

April 15, 2014

This is to certify that the parts listed below meets specifications as required by your order.

20 Units: D3969-3 B115924 Stainless Gas Spring

1 Unit: ~~D3552-17~~ B116399 Gas Spring

1 Unit: D3552-19 B116400 Gas Spring

Country of Manufacture: Canada

Date of Manufacture : April 2014

This product is ROHS compliant.

Purchase Order # 23791

Invoice # 11063

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
Manager